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RBE350A93-3312-03
Job Sheet 193180



Part No: RBE350A93-3312-03

Job Qty: 16 pcs

Part Name: Tail Rotor Hub Bushing Replacement Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/19

Job Tracking No:

Due Date: 5/6/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE350A93-3312-03 Rev G IPP Rev A 18.01.23 New issue DP Verify DD/IPP Rev B 18.03.08 DWG update Rev. G DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	16 pcs	5/6/19	5/6/19	0.00	1.60	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	16 pcs	5/6/19	5/6/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
130	Packaging 3-1 - Stock - B4B	16 pcs	5/6/19	5/6/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		



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Container No: S186550



Part: RBE350A93-3312-03

Job No: 193180

Serial No/Batch: S186550

Revision: G

Inspector:

Exp Date:

Instructions:

Date: 06/03/19

DAS
40
9-89

JUN 04 2019

					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - FG	16 pcs	5/6/19	0.00 0.00		QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - SA - 53	

Part Op **100** - (Small Fab) - Assemble as per DWG sheet 1.
 Descriptions: **110** - (QC5- Inspect part completeness to step on W/O)
130 - (Identify as per dwg & Stock Location: _____)
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90685A110	Hex Nut M12 X 1.75mm	16 Ea (1 ea)	100-Small Fab - 1	5172649
95327A708	Hex Head Screw M12 X 1.75mm x 100mm LG. (Mcmaster)	16 Ea (1 ea)	100-Small Fab - 1	113172652
RBE350A93-3312-03-1	Receiver	16 pcs (1 ea)	100-Small Fab - 1	1215173102
RBE350A93-3312-03-3	Remover / Installer	16 pcs (1 ea)	100-Small Fab - 1	3099930
RBE350A93-3312-03-5	Seat	16 pcs (1 ea)	100-Small Fab - 1	3092737
RBE350A93-3312-03-7	Washer	16 pcs (1 ea)	100-Small Fab - 1	3092754

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	90685A110	16	12	0
	95327A708	16	13	0
	RBE350A93-3312-03-1	16	15	0
	RBE350A93-3312-03-3	16	19	0
	RBE350A93-3312-03-5	16	18	0
	RBE350A93-3312-03-7	16	18	0

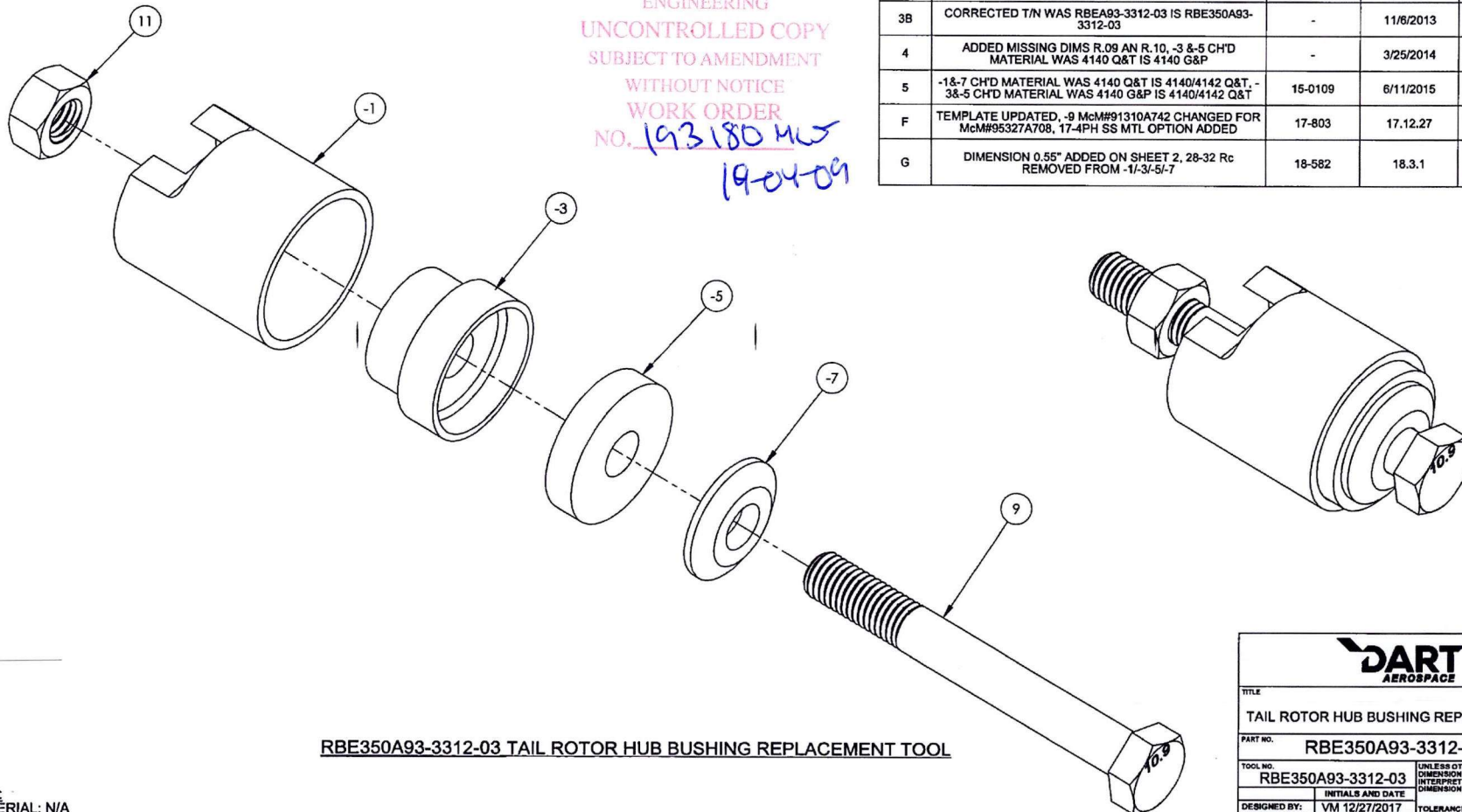
Part Specifications

Specifications could not be found.

ITEM #	QTY	PART #	TITLE
-1	1	RBE350A93-3312-03-1	RECEIVER
-3	1	RBE350A93-3312-03-3	REMOVER / INSTALLER
-5	1	RBE350A93-3312-03-5	SEAT
-7	1	RBE350A93-3312-03-7	WASHER
9	1	McMaster#95327A708	HEX HEAD SCREW M12 x 1.75 x 100mm LG.
11	1	McMaster#90685A110	HEX NUT M12 x 1.75

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 193180 MLJ
19-04-09

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
1	-01 ADDED S/N, "MADE IN USA"	-	4/29/2009	RJC	-
2	CHD ALL HOLES FROM 12.2mm TO 12mm FOR BETTER TOOL ALIGNMENT, CHANGES MADE TO MATCH CURRENT HELI-PRODUCTS TOOLS AND MORE OPEN TOLERANCES, -01 CHD DEPTH FROM .984 TO 1.06, ADDED R12 FOR LOOSER TOLERANCE, -03 CHD DIM FROM DIA 1.480 TO 1.487, FROM .939 TO .945, ADDED R.03, -05 CHD DIM WAS DIA 1.480 IS 1.487	-	9/30/2009	WP	RW
3	-01 CHD DIM WAS DIA 1.500 IS DIA 1.500 +0/-0.003	-	12/15/2010	RJC	RW
3A	-03 ADDED MISSING DIM .325	-	9/20/2011	RJC	GE
3B	CORRECTED T/N WAS RBEA93-3312-03 IS RBE350A93-3312-03	-	11/6/2013	RJC	RW
4	ADDED MISSING DIMS R.08 AN R.10, -3 & -5 CHD MATERIAL WAS 4140 Q&T IS 4140 G&P	-	3/25/2014	DPD	GE
5	-1& -7 CHD MATERIAL WAS 4140 Q&T IS 4140/4142 Q&T, -3& -5 CHD MATERIAL WAS 4140 G&P IS 4140/4142 Q&T	15-0109	6/11/2015	RJC	JAG
F	TEMPLATE UPDATED, -9 McMaster#91310A742 CHANGED FOR McMaster#95327A708, 17-4PH SS MTL OPTION ADDED	17-803	17.12.27	VM	ML
G	DIMENSION 0.55" ADDED ON SHEET 2, 28-32 Rc REMOVED FROM -1/-3/-5/-7	18-582	18.3.1	VM	ML



RBE350A93-3312-03 TAIL ROTOR HUB BUSHING REPLACEMENT TOOL

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A

DART AEROSPACE Hawkesbury, Ontario, Canada	
TITLE TAIL ROTOR HUB BUSHING REPLACEMENT TOOL	
PART NO. RBE350A93-3312-03	REV G
TOOL NO. RBE350A93-3312-03	
INITIALS AND DATE	
DESIGNED BY: VM 12/27/2017	TOLERANCES: XXX ± .005 FRACTIONS ± 1/8
DRAWN BY: VM 03/01/2018	XX ± .01 ANGLES ± .5°
CHECKED BY: VM 03/01/2018	X ± .1 SURFACE ROUGHNESS
MFG REVIEW BY: JFC 03/01/2018	SCALE: NTS SHEET 1 OF 5
APPROVED BY: ML 03/01/2018	
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					